

Technical Data Sheet

Handy Flo[®] 741 DF 741

GENERAL DESCRIPTION

Handy Flo 741 is a stable, corrosive flux system designed for use with aluminum brazing filler metals for joining of 1000, 3000, 6000 and some 5000 and 7000 series aluminum alloys in a dip brazing process. This dispensable flux consists of an exclusive combination of fluoride compounds only. This product is corrosive and requires a post braze cleaning or rinsing operation. The flux residue is easily dissolved in hot water at temperatures of 120°F (50°C) or higher.

Handy Flo 741 removes surface oxides that form on aluminum, which allows for excellent melt and flow characteristics of the filler metal. This product has been formulated to provide consistent dispensing features from either manual or automatic dispensing equipment. After paste application, assembly is placed in an oven and heated to 1000°F (537°C). The time at temperature will depend on the mass of the part plus the fixture. Preheating removes moisture and avoids a drain of heat from the salt bath. The assembly is immersed in the salt bath to allow parts to reach brazing temperature without excess alloying of the brazing alloy and the base metal.

The Handy Flo series are generally used in paste formulations containing braze filler metal, whereas DF 741 is a dispensable version of Handy Flo 741 distributed as flux formulation only without the braze filler metal content.

PRODUCT APPLICATION

Handy Flo 741 becomes fully molten and active by 1000°F (540°C). It is recommended for use with AL 713, AL 714, AL 716, and AL 718 braze filler metals in a ring, wire or strip form.

BRAZING CHARACTERISTICS

Handy Flo 741 and DF 741 will exhibit fast flow characteristics during the brazing operation. Handy Flo 741 and DF 741 leave behind no binder residue post-braze, with only flux residue present. The flux residue is water soluble and easily dissolved in hot water at temperatures of 120°F (50°C) or higher. Handy Flo 741 and DF 741 both exhibit restrictive slump characteristics, and thus can be used on vertical joints.

WARRANTY & STORAGE

Lucas-Milhaupt, Inc. warrants their Dispensable Flux products for 90 days from the date of shipment if stored in the original unopened container. Optimal storage conditions would be 65°F (18°C) - 75°F (24°C), clean and dry. It is recommended that the dispensable flux products are stored away from direct heat. Dispensable fluxes may require mixing to regain a homogenous mixture before application.

The 90 day warranty should not be interpreted as the shelf or useful life of the product. Dispensable fluxes may be used well beyond the 90 day warranty, unless customer testing or production results indicate unsatisfactory performance of the product.

AVAILABLE PACKAGING

Handy Flo and DF products are available in various size syringes, jars and cartridges. Dispensable flux may also be obtained in large containers prepackaged for immediate pneumatic dispensing operations.

SPECIFICATIONS

Handy Flo DF 741 conforms to the following specifications: N/A

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WARRANTY CLAUSE

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